

Date: Friday, 5/25/2007 12:53:26 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR WINDOW
Job Number : 32688	
Estimate Number : 10457	
P.O. Number : <i>N/A</i>	Part Number : D32121
This Issue : 5/25/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3212 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 30900	Material : Multiples of 4
Written By : <i>[Signature]</i>	Due Date : 6/7/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: A New Issue 05-11-09 JLM	
Est Rev: B Water jet/ ecn798 06-05-08 EC	
est rev.C back on haas 07.04.09 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
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Comment: Qty.: 1.0232 sf(s)/Unit Total : ~~20.4645~~ sf(s) *30.6965*  
 Material: 0.125" Polycast Sheet  
 (M-ACRYLIC-S.125)  
 Identify as D3212-1  
 Batch: *M103135* *ml 07 05 29* *(30)*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut blankas per Dwg D3212  
 Dwg Rev: *B* *ml 07 05 29* *(30)*  
 Prog Rev: *B*  
 2-Deburr if necessary

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA349 and Dwg D3212

*J.F. 07/06/04 (30)*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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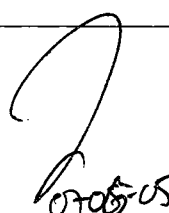

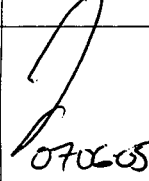


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.F. 07/06/04 (30)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01-06-05	1.	<del>2 of the</del> the holes in 2 of the windows were chipped.		had to scrap 2 windows	07-06-05 M.F.			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:53:26 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR WINDOW

Job Number: 32688

Part Number: D32121

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 07/06/04 x 30

6.0

D27281

Dart Logo label small



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Qty Part # Description Batch

1 D2728-1 Dart Logo label B 24215 -

MF 07-06-04 (38)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary

MF 07-06-04 28

2-Install label as per Dwg D3212

MF 07-06-05

3- polish abrasion scratches if necessary..

MF 07-06-05

4-Wrap in plastic wrap after inspection

MF 07-06-05 28

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 07/06/05 28

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

EP 07/06/05 (28)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(28)

Comment: FINAL INSPECTION/W/O RELEASE

07/06/05

Job Completion



MF 07-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32688
Description: Floor Window		Part Number:	D3212-1
Inspection Dwg: D3212	Rev: <del>A</del> B	07.05.26	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.734"	✓			
6.367	+/-0.005	6.367"	✓			
0.625	+/-0.005	.628"	✓			
0.156	+0.005/-0.000	Ø.157"	✓			
R0.25	+/-0.030	R0.25"	✓			
8.150	+/-0.005	8.150"	✓			
3.750	+/-0.005	3.750"	✓			
0.313	+/-0.010	.319"	✓			
15.14	+/-0.030	15.140"	✓			
12.520	+/-0.005	12.520"	✓			
6.260	+/-0.005	6.260"	✓			
1.312	+/-0.005	1.314"	✓			
0.313	+/-0.010	.315"	✓			
3.750	+/-0.005	3.750"	✓			
8.150	+/-0.005	8.150"	✓			
8.462	+/-0.005	8.462"	✓			
9.09	+/-0.030	9.091"	✓			

Measured by: JF	Audited by: En	Prototype Approval:	N/A
Date: 07/06/03	Date: 07/06/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue	KJ/RF	JF

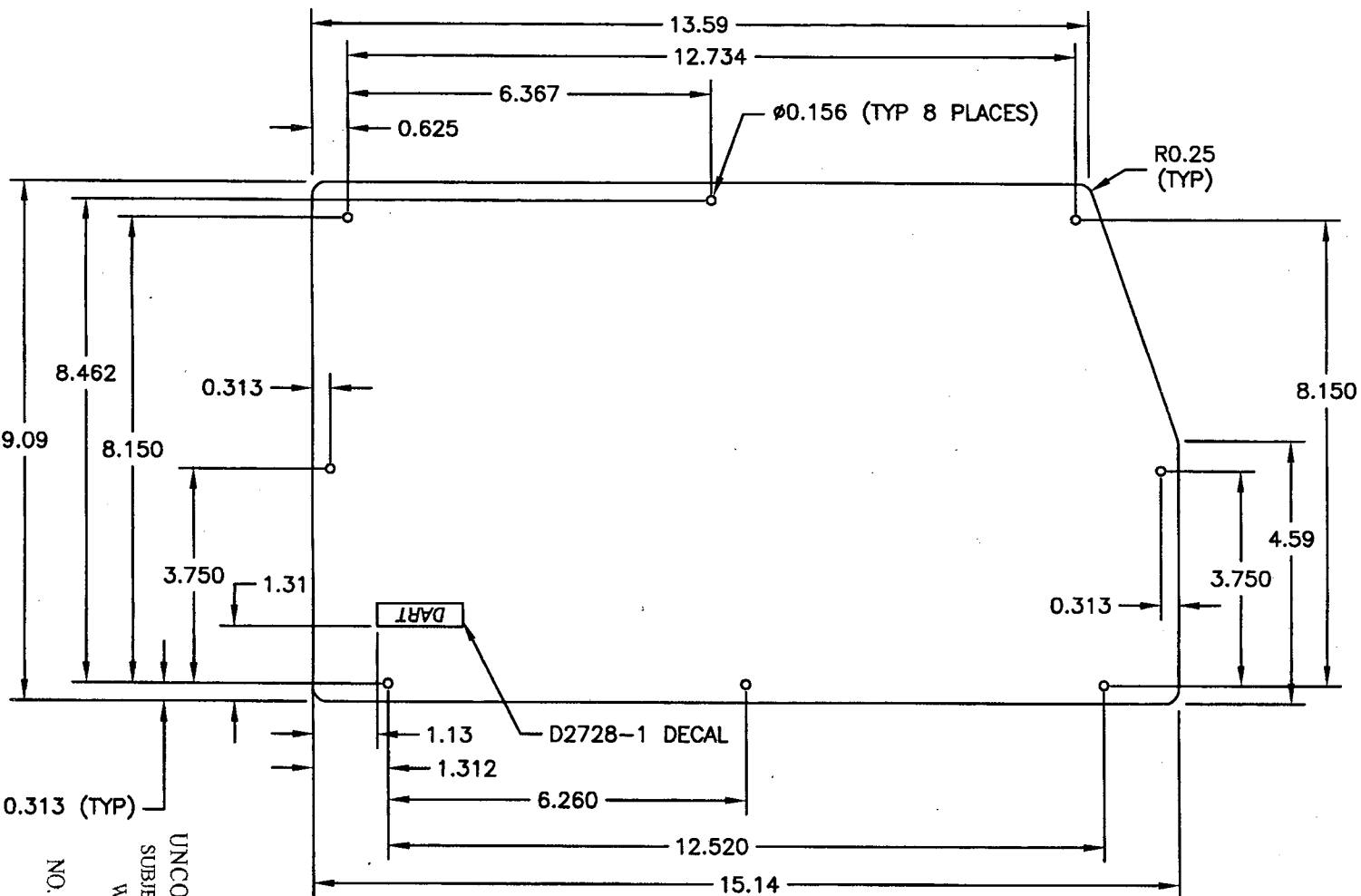
*[Handwritten signature]*

**DART**

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CP	SSH		
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3212	SHEET 1 OF 1
DATE	TITLE		SCALE
06.04.13	FLOOR WINDOW		1:3
A	03.09.03	NEW ISSUE	
B	06.04.13	UPDATE MATERIAL PER NCR 029	

D3212-1 FLOOR WINDOW

- 1) CHECK DIMENSIONS WITH TEMPLATE D3212-1T1
- 2) DIMENSIONS ARE IN INCHES AND ARE FOR REFERENCE ONLY
- 3) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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